

Date: Thursday, 5/4/2006 11:10:05 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: REPLACEMENT WINDOW ASSEMBLY	
Job Number	: 26932		Part Number	: D3290041	
Estimate Number	: 11174		Drawing Number	: D3290 REV A/B	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 5/4/2006	S.O. No. : N/A	Drawing Revision	: AB 06.06.03	
Prsh Rev.	: NC		Material	: N/A	
First Issue	: N/A		Due Date	: 5/18/2006	
Previous Run	: 26454		Qty:		
Written By	: See comment below		Um:	Each	
Checked & Approved By	: [Signature]				
Comment	: Est. B 05.05.25 Added Step 11 KJ/JLM				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PG	PURCHASING order 20 Comment: PURCHASING Issue P/O: Manufacture D3290-1 as per Dwg D3290 Possible Supplier: GFI Material release note is required
2.0	D32901F / D32901F	Window Frame R/I # 1249 C LOG105115 (20) - Comment: Qty.: 1.0000 U(s)/Unit Total : 6.0000 U(s) Replacement Window Assy
3.0	PACKAGING 1	PACKAGING RESOURCE #1 Comment: PACKAGING RESOURCE #1 Recieve & Inspect for Transit Damage Ensure Material Release Note is attached
4.0	QC6	DIMENSIONAL CHECK Comment: DIMENSIONAL CHECK
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1 Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 5/4/2006 11:10:05 AM
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Drawing Name: REPLACEMENT WINDOW ASSEMBLY

Job Number: 26932

Part Number: D3290041

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

DL 06/06/07 20

7.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

DL 06/06/07 20

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

240 06:06:08 20

9.0 D21260780

Locking Seal



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Locking Seal

Pick:

Qty	Part Number	Description	Batch
1	D2126-0780	Locking Seal	B23696 0220 (1)

B23696 0220 (1)

B25702 (5)

10.0 D32901

Window Frame



Comment: Qty.: 0.0000 Each(s)/Unit Total : 0.0000 Each(s)

Window Frame

Pick:

Qty	Part Number	Description	Batch
1	D3290-1	Window Frame	B26932x5 B23004 (2)

B26932x5 B23004 (2)

PP

11.0 D32903

Window



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Window

Pick:

Qty	Part Number	Description	Batch
1	D3290-3	Window	B27090

B27090

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
06/06/09	10	15 frames put in stock (missing seal to complete)	SK				

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 06/06/12
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: REPLACEMENT WINDOW ASSEMBLY

Job Number: 26932

Part Number: D3290041

Job Number:



Seq. #: Machine Or Operation:

Description :

12.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D3290

Clean D3290-041 and place in plastic wrap

SAD 06:06:08

7

P10

13.0 QC5

INSPECT WORK TO CURRENT STEP



7

Comment: INSPECT WORK TO CURRENT STEP

14.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

→ Clean & wrap in Plastic
In a very clean, debris free area.

Identify and Stock

Location: ST.6

26/6/08 (7)

7

15.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

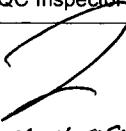
Inspection Level 21

26/6/08 (7)

Job Completion



U 06.06.12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
06-06-08	12	Cleani. wrap A + step 14 as stated, in a clean & debris free department. Permanent change.					 06-06-09

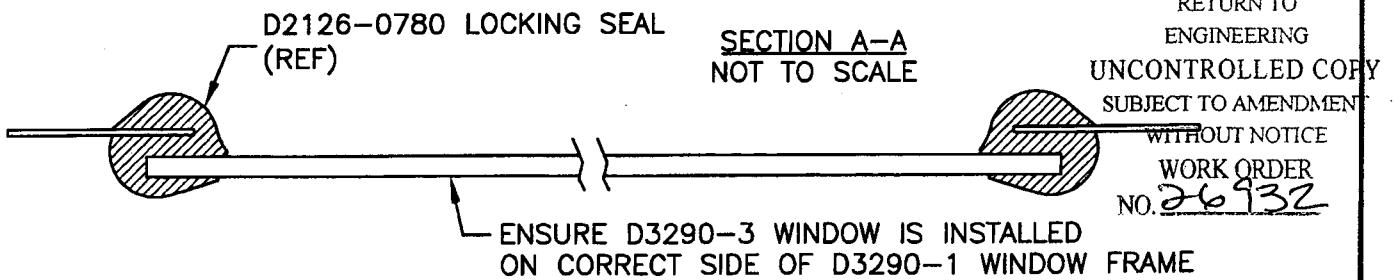
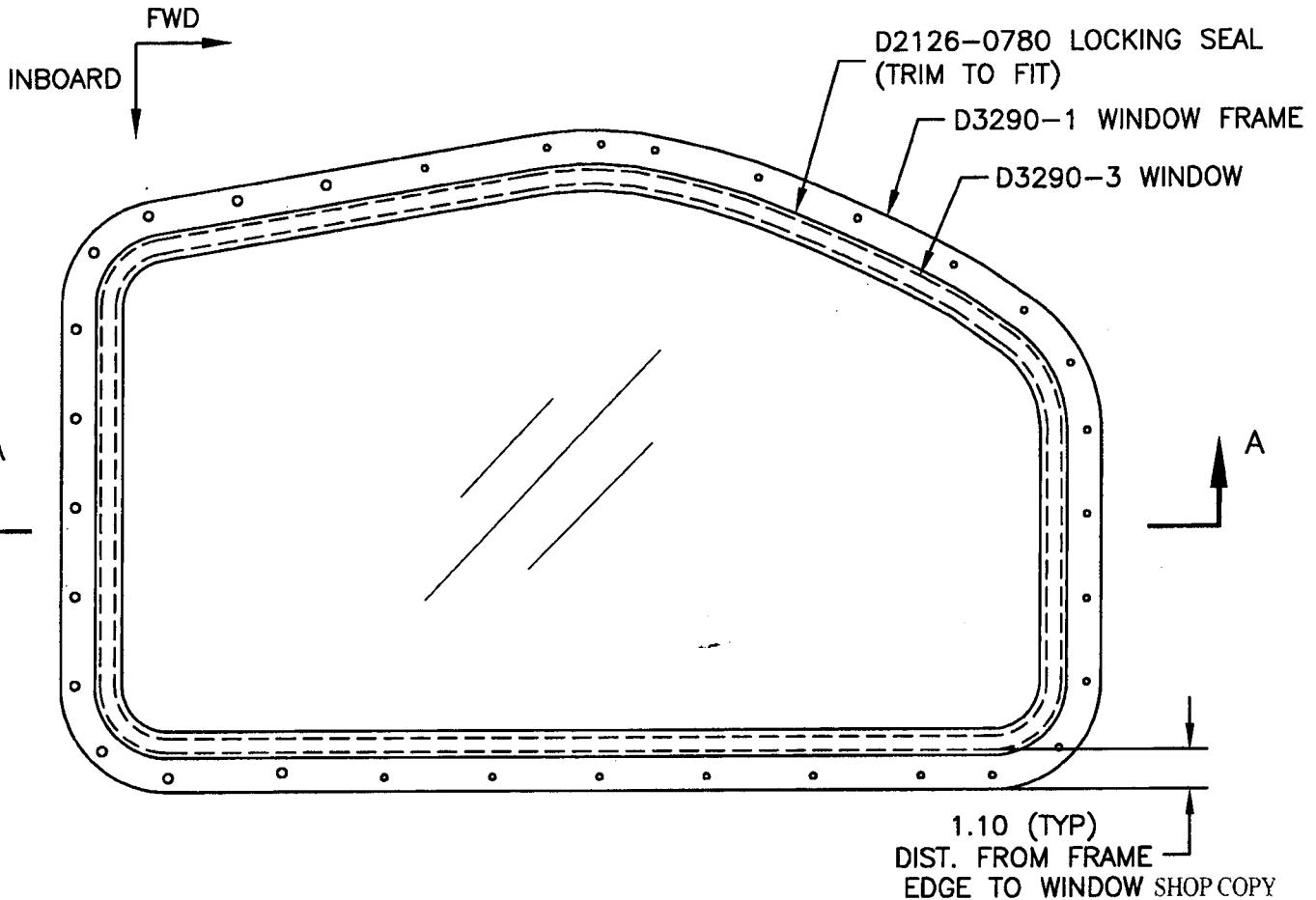
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN RF	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3290	REV. B SHEET 1 OF 3
DATE 06.04.20		TITLE REPLACEMENT WINDOW ASSEMBLY	SCALE 1:5
	A	04.06.14	NEW ISSUE
	B	06.04.20	UPDATE MATERIAL PER NCR 029

**D3290-041**

RELEASED

06.04.20 *[Signature]***NOTES**

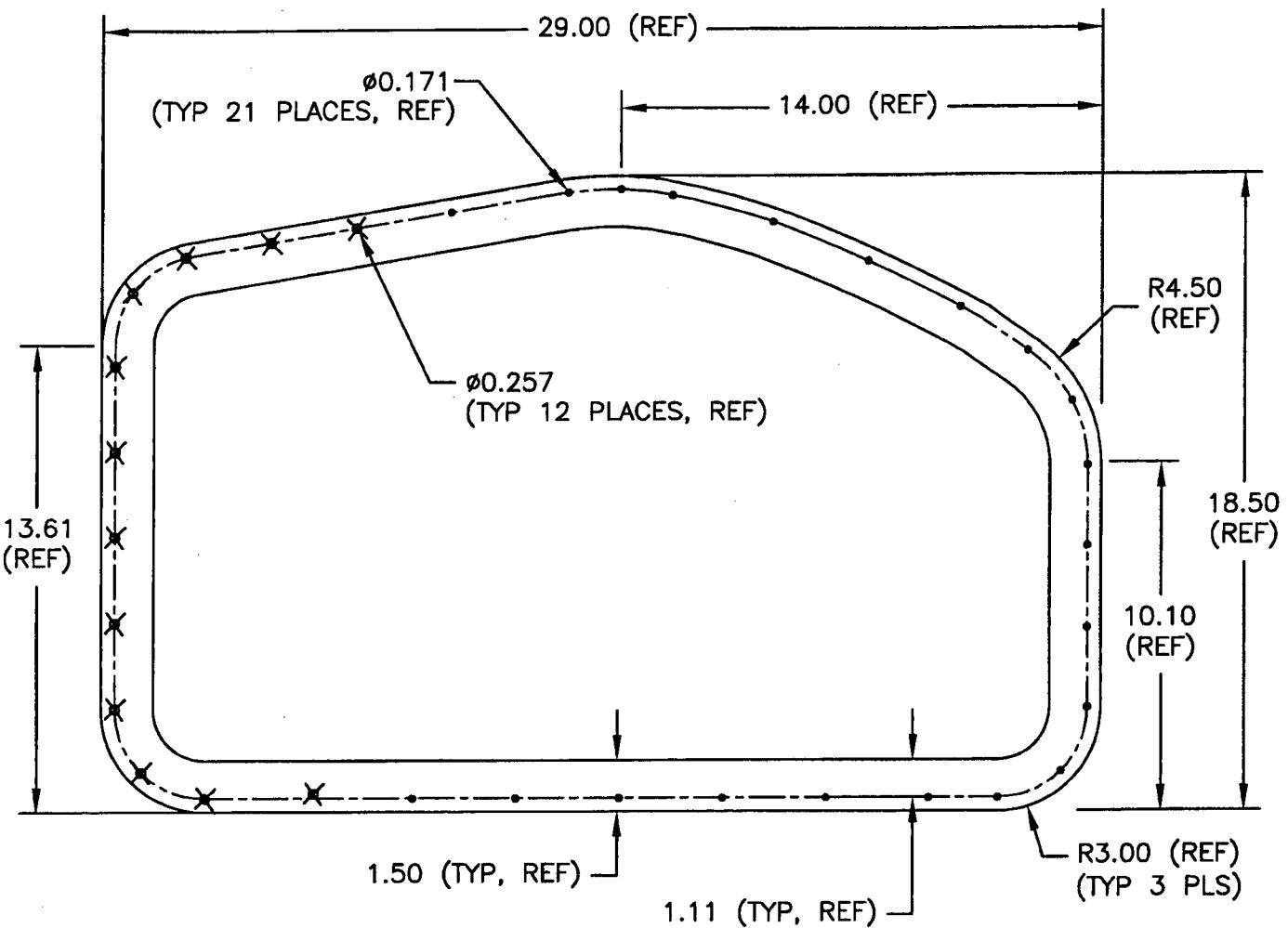
- 1) ALL DIMENSIONS ARE IN INCHES
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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DART

DESIGN RF	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3290	REV. B SHEET 2 OF 3
DATE 06.04.20	TITLE REPLACEMENT WINDOW ASSEMBLY	SCALE 1:5	

**D3290-1 FRAME****D3290-1**

- 1) MACHINE PER DRAWING FILE "D3290-A2.DWG"
- 2) MATERIAL: 5052-H32 (QQ-A-250/8) SHEET 0.040 THICK
- 3) FINISH: CHEMICAL CONVERSION COAT PER QSI 005 4.1
POWDER COAT WHITE (REF. 4.5.3.1) PER DART QSI 005 4.3 WITHOUT NOTICE
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

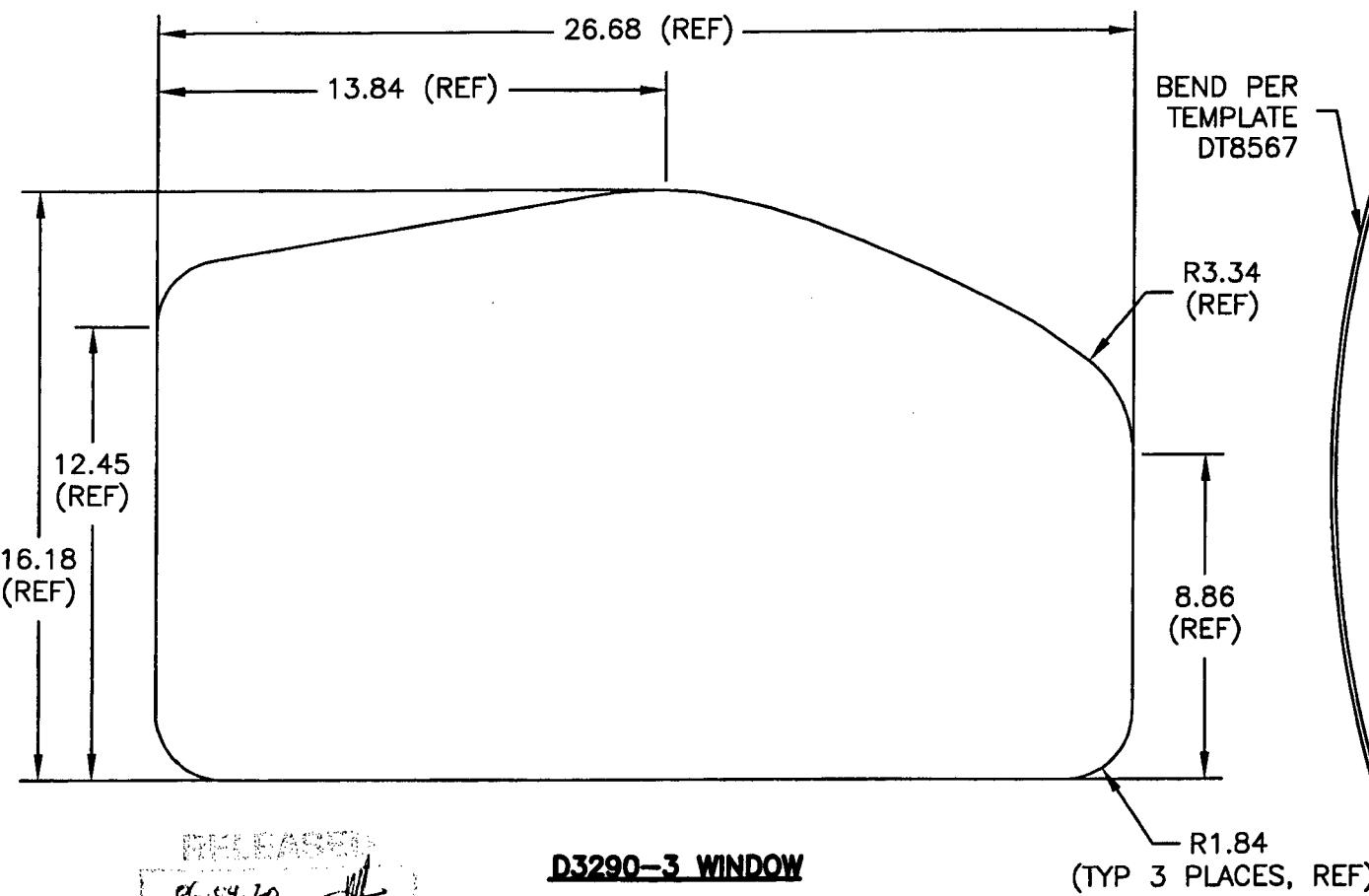
PREPARED BY: *[Signature]* SHOE COPY
06.04.20 RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WORK ORDER
NO. *26932*

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DART

DESIGN RF	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3290
DATE 06.04.20		TITLE REPLACEMENT WINDOW ASSEMBLY

REV. B
SHEET 3 OF 3
SCALE
1:5

- D3290-3**
- B**) 1) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425
OR PLEXIGLAS G CLEAR CAST ACRYLIC SHEET PER
LP-391 TYPE 1 GRADE C, 0.125 THICK
(REF. DART SPEC. M-ACRYLIC-S.125)
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) CHECK PART USING DT3290-3T1
- SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 36932

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180 AVENUE LABROSSE
POINTE-CLAIRE, QUÉ., CANADA H9R 1A1
TÉL.: (514) 630-4877 - FAX: (514) 630-4849



BON DE LIVRAISON - SHIPPING MEMO

DATE DE LIVRAISON
SHIPPING DATE

N° BON DE LIVRAISON
SHIPPING MEMO NO.

2006/05/30

0338152

GFI est une division de Thomas & Betts Fabrication Inc. / GFI is a division of Thomas & Betts Manufacturing Inc.

VENDU À / SOLD TO

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON, K6A 1K7

EXPÉDIÉ À / SHIPPED TO

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON, K6A 1K7

CODE DE CLIENT CUSTOMER CODE	N° DE CONTRAT JOB NO.	N° COMMANDE PO NO.	VIA SHIP VIA
DART GFI-0299	J0143533	PO00001249	
QUANTITÉ QUANTITY	VOITRE N° DE PIÈCE YOUR PART NO.	DESCRIPTION	
20	D32001F <i>see 2 flaked</i>	WINDOW FRAME	

TOUTES LES RÉCLAMATIONS DOIVENT ÊTRE FAITES EN DEDANS DE 5 JOURS DE LA RÉCEPTION
ALL CLAIMS MUST BE MADE WITHIN 5 DAYS OF RECEIPT OF GOODS.

REÇU PAR / RECEIVED BY



Division de / Division of Thomas & Betts

6971 Inc.
102 Avenue LaSalle
Pointe-Claire, Quebec
Canada H9R 1A7
Tel: (514) 632-4877
Fax: (514) 632-4849

NO. DU BON DE COMMANDE:
PURCHASE ORDER NUMBER: P00000(249)

NO. DE LA PIÈCE:
PART NUMBER: 032901F

DESCRIPTION: WINDOW FRAME

QUANTITÉ:
QUANTITY: 20

BORDEREAU D'EMBALLAGE:
PACKING SLIP NUMBER: 338152

DATE: MAY 30/06

CERTIFICAT DE CONFORMITÉ / CERTIFICATE OF CONFORMANCE

ATTENTION: INSPECTION À LA RÉCEPTION / RECEIVING INSPECTION

Le soussigné certifie que le matériel fourni et les pièces qui ont été achetées et expédiés selon le Bon de Commande portant le numéro mentionné ci-dessus et selon le bordereau d'emballage, sont conformes aux spécifications contractuelles applicables, aux exigences du Bon de Commande et de celles des dessins applicables. Les rapports applicables à ces commandes sont gardés en fichiers et peuvent être fournis sur demande.

The undersigned hereby certifies that the material and the items purchased and shipped herewith under the above purchase order and on the packing slip are in conformance with all the contractual applicable specifications, purchase order requirements and drawing requirements and reports are on file and will be made available upon request.

GFI Division of Thomas & Betts



Département de contrôle de la qualité
Quality Control Department

FORM: F-048

REV.: 02

RHL: 04/01



Membre de / A Member of **Thomas & Betts**

180 LABROSSE AVENUE
POINTE CLAIRE, QC
H9R 1A1

CERTIFICATE OF COMPLIANCE

CERTIFICAT DE CONFORMITÉ

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7

CERTIFICATE NO. **1** OUR JOB NO **J0143533** SHIPPING MEMO **0338152**

ITEM QUANTITY PURCHASE ORDER PART NUMBER REV NAME DWG ISSUE

20 PCS **PO00001249** **D3290-1** **See 2H 2nd** **WINDOW FRAME** **B**

MATERIAL

SUPPLIED BY

MAT. REL. NO.

AL 5052-H32

SAMUEL SPECIALTY / ORMET

D365146-004 ATT'D

PROCESS

PROCESSOR

RELEASE NOTE #

1			
2			
3			
4			
5			
6			
7			
8			
9			

WE HEREBY CERTIFY ALL THE PARTS COVERED BY THIS CERTIFICATE HAVE BEEN MANUFACTURED FROM MATERIAL SUPPLIED ON RELEASE NOTE SHOWN ABOVE AND THAT ALL PARTS HAVE BEEN INDIVIDUALLY INSPECTED AND CONFORM TO THE DRAWINGS AND PURCHASE ORDER REFERENCED ABOVE.

DATE **30 MAY 2006**

G.F.I. Q.C. REP.

R.S. Somer



342-06

**LES MÉTAUX
SPÉCIALISÉS**
SAMUEL

Programme d'Assurance Qualité Enregistré / Registered Q.A. Program
ISO 9001:2000 AS9100

LETTRE DE CONFORMITÉ –LETTER OF COMPLIANCE

Date: 23 MAI 2006

Company Name: G.F.I. Division of Thomas & Betts limited
Address: 180 avenue Labrosse
City: Pointe Claire, Qué.
Zip Code: H9R 1A1

du client: 0060414 **# de commande SSMQ:** 855252
Customer's order #: SSMQ's Order #:

La présente est pour certifier que le matériel détaillé ci-dessous est conforme aux exigences de votre commande et des normes du grade tel que décrit:

The following is to certify that the material listed below meets your order requirements and grade standards as described:

Notre/Our Item #	# de pièces/ # of pieces	Épaisseur/Grandeur Guage/Size	Alliage/Trempe Alloy/Temper	Spécification / Spécification	Lot/Heat
2	4	.040" X 48" X 96"	5052 H32		D365146-004

Bien à vous,
Yours truly,



Marie Griffeth
Commis à l'administration.
Administration Clerk.



OR 1902

Must be electronically approved

CERTIFICATION OF INSPECTION & TEST RESULT

SOLD TO: SAMUEL, SON & CO. LIMITED 2225 FRANCIS HUGHES LAVAL QC H7S 1 N5		SHIP TO: SAMUEL, SON & CO. LIMITED 900 CUNARD LAVAL QC H7S 2 H6					
ORDER NUMBER 005619800	B/L # R047719	SHIPPING POINT FD	SHIP DATE 10/10/2005				
PURCHASE ORDER NUMBER C58523 PREBILL		CARRIER TRANSPORT PEREZ	TYPE CERTS N/A				
ITEM	DESCRIPTION	TENSILE KSI		YIELD KSI		% ELONGATION	
		MIN	MAX	MIN	MAX	MIN	MAX
001-01	5052 H32 00.04000 48.0000 MF-CS VMA	33.1	33.8	26.1	27.1	11	14
PART NO. CD5052040048800							
LOT TICKET D365146-004							
SPECIFICATIONS AMS-QQ-A-250-8A (9/98) ASTM B209 (5/2001)				WEIGHT Lbs 6,664			



OR 1902

Must be electronically approved

CERTIFICATION OF INSPECTION & TEST RESULT

SOLD TO: SAMUEL, SON & CO. LIMITED 2225 FRANCIS HUGHES LAVAL QC H7S 1 N5	SHIP TO: SAMUEL, SON & CO. LIMITED 900 CUNARD LAVAL QC H7S 2 H6
ORDER NUMBER 005619800	B/L # R047719
PURCHASE ORDER NUMBER C58523 PREBILL	SHIPPING POINT FD SHIP DATE 10/10/2005 TYPE CERTS N/A CARRIER TRANSPORT PEREZ

Actual Chemistry Chemical Composition Limits of Wrought Aluminium Alloy

LOT TICKET	SI	FE	CU	MN	MG	CR	ZN	TI	OTHERS	AL
									EACH	TOTAL
D365146-004	0.10	0.30	0.02	0.04	2.2	0.16	0.02	0.03	..	Rem

5052

CERTIFICATION OF INSPECTION AND TEST RESULTS

"Ormet Aluminum Mill Products Corporation certifies that the material used in the fabrication of this order has been inspected and tested and found to be in conformance with the requirements of applicable specifications shown in the item description indicated herein. Test reports for this material are on file subject to examination."

"No aluminum produced by Ormet Aluminum Mill Products Corporation contains concentrations of heavy metals (lead, mercury, cadmium and hexavalent chromium) greater than the trace amounts allowed by governmental regulation, CONEG recommendations, and are in compliance with the state of California's Safe Drinking Water and Toxic Enforcement Act ("Proposition 65") restrictions on "known carcinogens and reproductive toxins". There are no Proposition 65 listed chemicals present at concentrations that exceed the established no observable effects levels (NOEL) for reproductive toxicants or significant risk levels for carcinogens. No greenhouse ozone depleting gases or materials contaminated with asbestos, hazardous waste or radioactivity are used for the production of metal."

"This certification shall be deemed a part of and subject to all the Terms and Conditions set forth on the front and reverse sides of Ormet Aluminum and/or order Acknowledgment forms."

BY:

CERTIFYING AUTHORITY